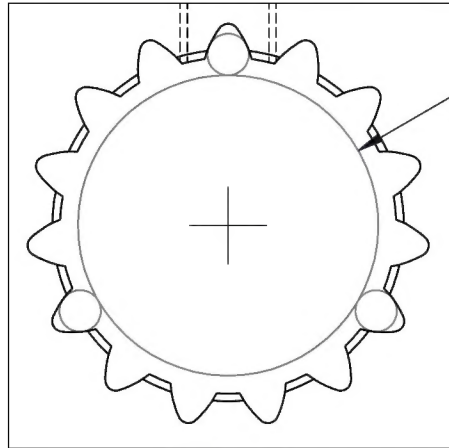
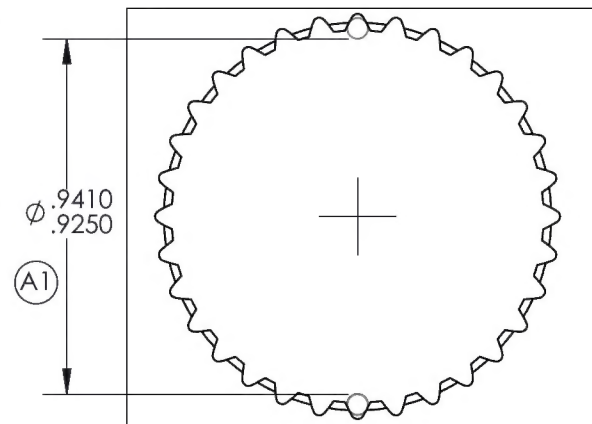


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DETAIL A  
SCALE 2 : 1

SPLINE DATA A	
NO. TEETH	15
DIAMETRAL PITCH	16/32
PRESSURE ANGLE	30°
BASE DIA.	.8119
CIRCULAR PITCH	.1963
PITCH DIA.	.9375
MAJOR DIA.	1.0500
MINOR DIA.	.8767 - .8900
FLAT OR FILLET	OPTIONAL



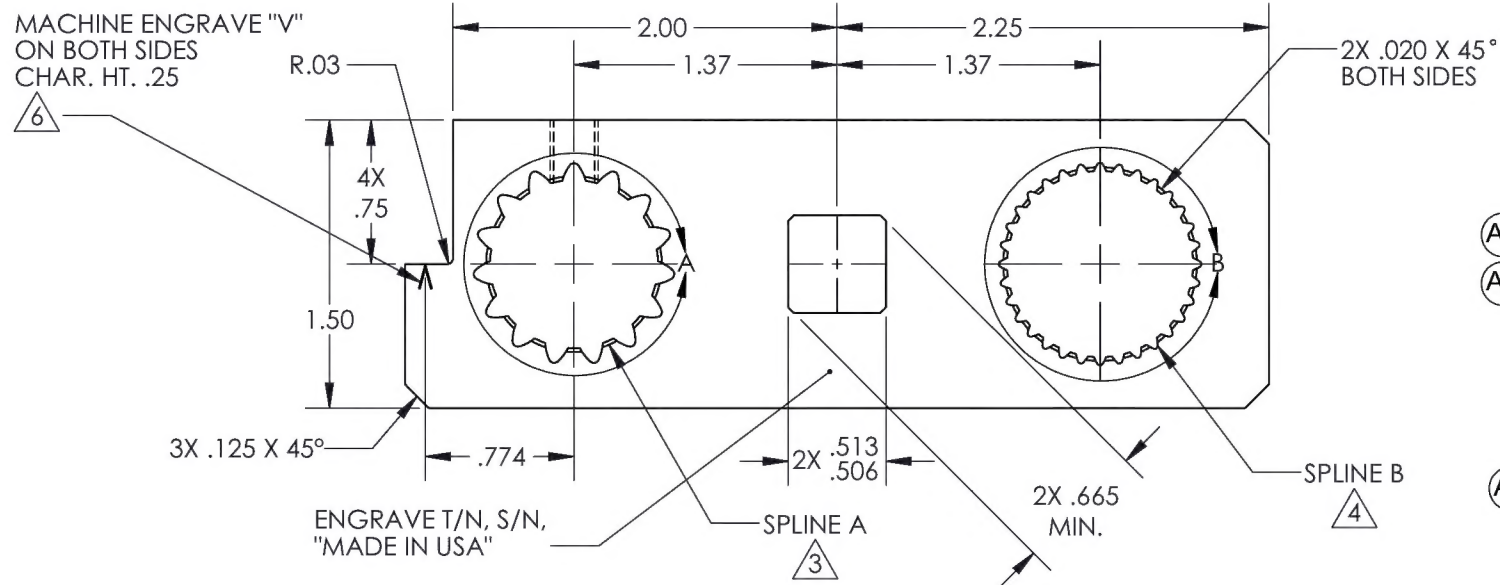
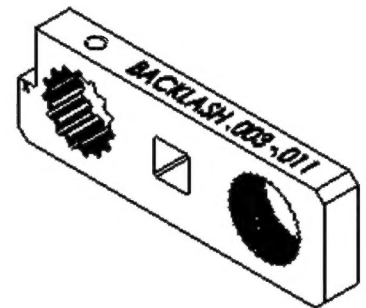
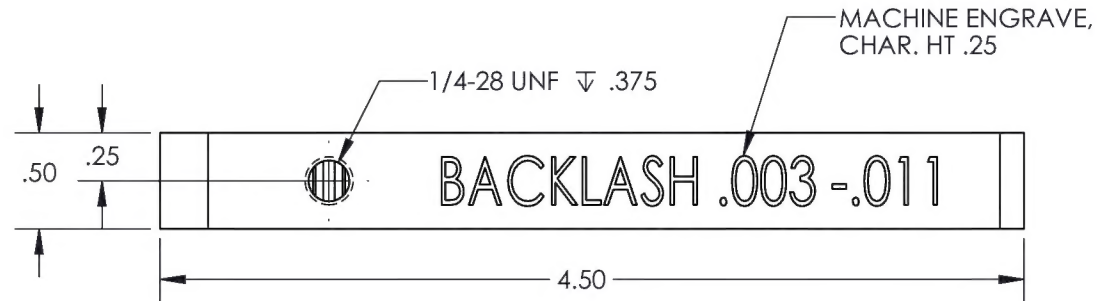
DETAIL B  
SCALE 2 : 1

SPLINE DATA B	
NO. TEETH	32
DIAMETRAL PITCH	32/64
PRESSURE ANGLE	30°
BASE DIA.	.8660
CIRCULAR PITCH	.0982
PITCH DIA.	1.0000
MAJOR DIA.	1.0563
MINOR DIA.	.9688 - .9820
FLAT OR FILLET	OPTIONAL

$\phi .7940$   
 $\phi .7772$   
OVER 3  $\phi .108$  PINS  
(A1)

TOOL USAGE BLOCK							
COLUMN	V2	V3	V4	V5	V6	V7	V8
PARA	REMARKS	TOOL No.	OPER.	P/N & NAME	OPER.	P/N & NAME	ON ASSY. No.
1	206 SERIES	T101511	TO HOLD	206-040-405 PINION	TORQUE REMOVE	NAS 1493-7 NUT	206-040-400
2	206 SERIES	T101511	TO HOLD	206-040-407 SHAFT	TORQUE REMOVE	206-040-421 NUT	206-040-400
3	206 SERIES	T101511 T101510	CHECK BACKLASH	206-040-405 PINION	TO	206-040-406 GEAR	206-040-400

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



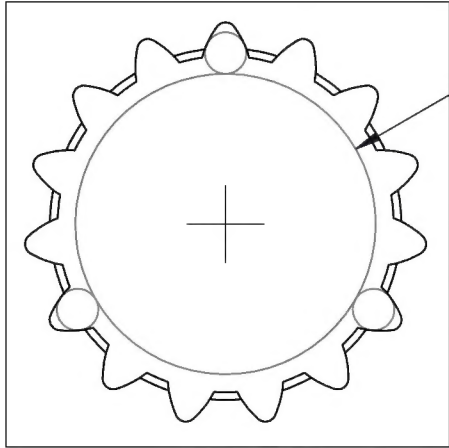
- NOTES:
- BREAK EDGES .015 OR .015x45° CHAMFER EXCEPT AS NOTED.
  - MARK PER BPS FW 4050.
  - (A1) BROACH SIMILAR TO 206-040-328.
  - (A1) BROACH SIMILAR TO 206-010-776.
  - ALTERNATE SETSCREW - AN 565F428H8.
  - POSITION DIAL INDICATOR IN LINE WITH LETTER "V" TO MEASURE BACKLASH.
  - ALTERNATE MATERIAL - COMERCIAL 4130 STEEL.
  - (A1) 8. THIS TOOL HAS BEEN COMPENSATED FOR CHECKING BACKLASH IN PLANE OF ROTATION.
  9. SOME HIDDEN LINES OMITTED FOR CLARITY.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-3	1	BAR	4140	5/8 x 1-5/8 x 4-5/8	
		B/O	-5	1	SOCKET HEAD SET SCREW		1/4-28 X 1/2 UNF #AN565A428H8	N/S

RED BARN MACHINE			
TITLE SPLINE WRENCH TAIL ROTOR GEAR BOX			
DWG NO. RB T101511			REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: CLOUGH	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1		APPROVED <i>D. Weil</i>	
FRACTIONS ± 1/32 ANGLES ± .5°		TREAT RC 32-38	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		SPEC	
SCALE 1:1		USED ON MODEL SEE TABLE	
DATE 11/9/2011		SHEET 1 OF 2	

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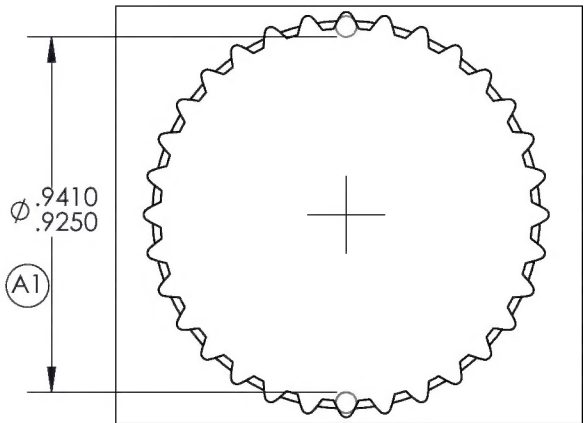
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
APPROVED			



$\phi .7940$   
 $\phi .7772$   
OVER 3  $\phi .108$  PINS

DETAIL A  
SCALE 2 : 1

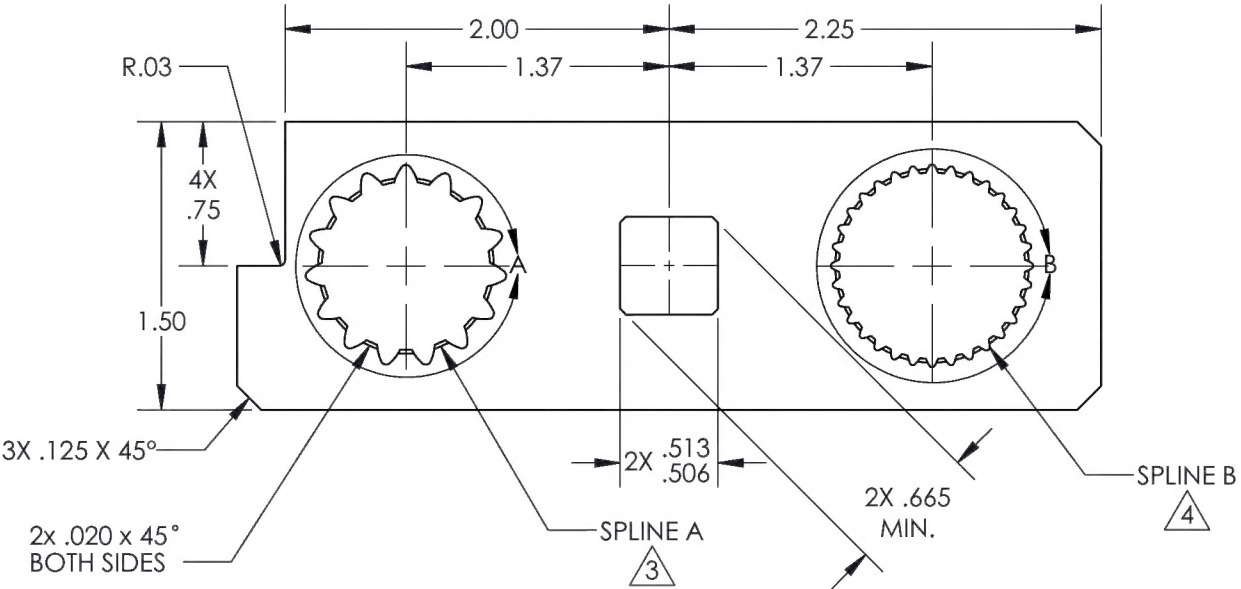
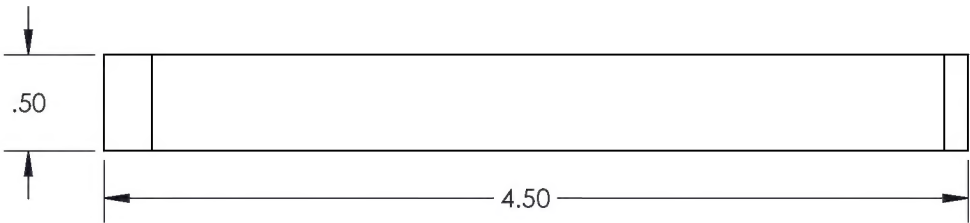
SPLINE DATA A	
NO. TEETH	15
DIAMETRAL PITCH	16/32
PRESSURE ANGLE	30°
BASE DIA.	.8119
CIRCULAR PITCH	.1963
PITCH DIA.	.9375
MAJOR DIA.	1.0500
MINOR DIA.	.8767 - .8900
FLAT OR FILLET	OPTIONAL



DETAIL B  
SCALE 2 : 1

SPLINE DATA B	
NO. TEETH	32
DIAMETRAL PITCH	32/64
PRESSURE ANGLE	30°
BASE DIA.	.8660
CIRCULAR PITCH	.0982
PITCH DIA.	1.0000
MAJOR DIA.	1.0563
MINOR DIA.	.9688 - .9820
FLAT OR FILLET	OPTIONAL

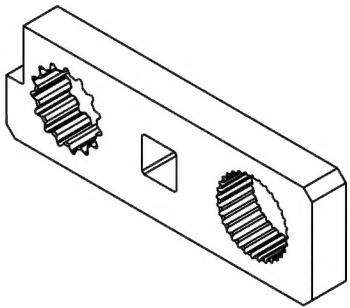
TOOL USAGE BLOCK							
COLUMN	V2	V3	V4	V5	V6	V7	V8
PARA	REMARKS	TOOL No.	OPER.	P/N & NAME	OPER.	P/N & NAME	ON ASSY. No.
1	206 SERIES	T101511	TO HOLD	206-040-405 PINION	TORQUE REMOVE	NAS 1493-7 NUT	206-040-400
2	206 SERIES	T101511	TO HOLD	206-040-407 SHAFT	TORQUE REMOVE	206-040-421 NUT	206-040-400
3	206 SERIES	T101511 T101510	CHECK BACKLASH	206-040-405 PINION	TO	206-040-406 GEAR	206-040-400



(-3)

BAR

WATER JET



NOTES:

- BREAK EDGES .015 OR .015x45° CHAMFER EXCEPT AS NOTED.
- MARK PER BPS FW 4050.
- (A1) BROACH SIMILAR TO 206-040-328.
- (A1) BROACH SIMILAR TO 206-010-776.
- (7) ALTERNATE MATERIAL - COMERCIAL 4130 STEEL.
- (A1) 8. THIS TOOL HAS BEEN COMPENSATED FOR CHECKING BACKLASH IN PLANE OF ROTATION.
9. SOME HIDDEN LINES OMITTED FOR CLARITY.

RED BARN MACHINE			
TITLE			
SPLINE WRENCH TAIL ROTOR GEAR BOX			
DWG NO.			REV
RB T101511-3			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: CLOUGH	
TOLERANCES ON:		APPROVED <i>D Weil</i>	
DECIMALS		TREAT RC 32-38	
.XXX ± .005		FINISH CAD YELLOW	
.XX ± .01		SPEC QQ-P-416F, TYPE II, CLASS II	
.X ± .1		USED ON MODEL	
UNLESS OTHERWISE SPECIFIED		SEE TABLE	
1. BREAK ALL SHARP EDGES			
.015 x 45° PR .015 R			
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE	1:1	DATE	11/9/2011
		SHEET 2 OF 2	